Page 1

Item ID: D3017-7 Accept Setup Start **Revision ID:** Α Stop Item Name: Lug **Start Qty: 10.00 Start Date:** 10/19/09 **Cust Item ID:** Required Date: 11/02/09 Reg'd Oty: 10.00 **Customer:** Reference: Start Run Date: 09-10-19 Tooling: Process Plan: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Plan Accept Reject Draw Draw Reject Insp. **Work Center ID** Description Qty Number **Run Hours** Number Rev. Code Qty Stamp **Draw Nbr Revision Nbr** D3017 Rev A 100 0.00 FLOW WATER JET 18 9-11-5 Waterjet 0.00 Memo FLOW CNC Wateriet 1-Cut as per Dwg D3017 4130 Dwg Rev: Prog Rev: 040 2-Deburr 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control



October 19, 2009 12:46:18 PM

Item ID:

D3017-7

Α

Item Name: Lug

**Start Date:** 

Revision ID:

10/19/09

Required Date: 11/02/09

**Start Oty: 10.00** 

Reg'd Oty: 10.00



Accept

Setup Start

Stop



Reference:

**Approvals:** 

Process Plan: Date:

Tooling:

QC: Date: SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00 => Sortulo5

0.00

Draw

Number

**Cust Item ID:** 

**Customer:** 

Draw Plan Rev.

Date:

Code

Accept Reject Oty colon

Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr

2-Form as per Dwg D3017 using DT8598

140

**Quality Control** 

QC5- Inspect part completeness to step on W/O

Memo

0.00 SB 09/11/06

## Work Order ID 52915

October 19, 2009 12:46:18 PM



Page 3

Item ID:

D3017-7

Accept

Setup Start

Stop



Revision ID: Item Name:

Α Lug

10/19/09

Required Date: 11/02/09

Start Qty: 10.00

Req'd Qty: 10.00

**Cust Item ID: Customer:** 

Draw

Number

Reference:

**Start Date:** 

Approvals:

**Process Plan:** 

Date: \_\_\_\_\_

**Tooling:** 

Date:

Run Start

QC: \_\_\_\_ Date: \_\_\_\_ SPC (Y/N):

Operation

Description

Packaging

Set Up/

0.00

0.00

**Run Hours** 

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Reject Qty

Stop

Reject Number Stamp

Insp.

**Work Center ID** 150

Sequence ID/

Packaging

Packaging

Memo

Identify and bag with light oil (Vactra oil #2), then Stock

Location:

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

BA 09-11-9

## **Picklist Print**

October 19, 2009 12:46:24 PM

Work Order ID: 52915

Parent Item:

Comments:

D3017-7RevA

Parent Item Name: Lug



**Start Date: 10/19/09** 

Required Date: 11/02/09

**Start Qty: 10.00** 

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NS.049		Purchased	No		·	100	sf	26.9300		5.5		
4130 Shoot, 040											189-11	-5

4130 Sheet .049

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	26.93		
11612	11.43		
16443	15.5		16443

DART AEROSPACE LTD	Work Order:	52915	
Description: Lug	Part Number:	D3017-7	
Inspection Dwg: D3017 Rev: A		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.25	+/-0.030	.95	*			
2.063	+/-0.010	2.069	*	i	-	
2.500	+/-0.010	2,493	Ø			
Ø0.191	+0.005/-0.000	,194	*			
			<u> </u>			
		a.				
·		<del></del>				
						<del></del>
<u>.</u>						
			1		•	

			$\sim$				
Measured by:	图	Audited by:	2		Р	rototype Approval:	N/A
Date:	9-11-5	Date:	වදි	14/05		Date:	N/A

Rev	Date	Change	Revised by	Approxed
Α	05.03.04	New Issue	KJ/JLM	
	•			1,0,1





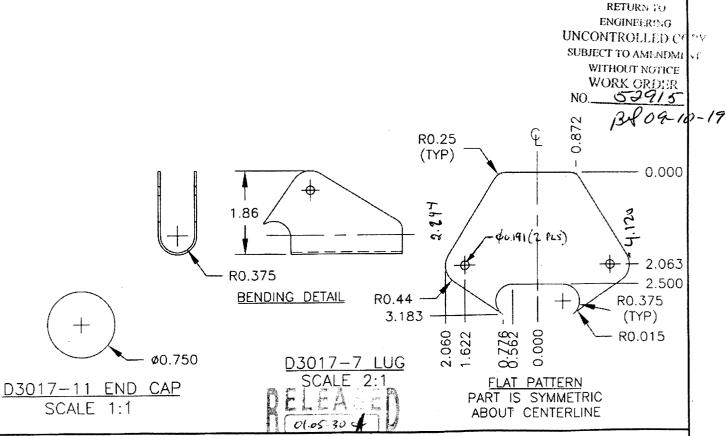
DESIG	N P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHECK	(ED d	APPROVED	DRAWING NO.	REV. A
	4	#	D3017	SHEET 1 OF 2
DATE			TITLE	SCALE
01.0	)5.18		BACK FRAME ASSEMBLY	1:1
Α		01.05.18	NEW ISSUE	

SHOPCOTY

QTY	PART No.	DESCRIPTION	MATERIAL
Х	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

## **NOTES**

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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